

shop 17/10

Dart Aerospace Ltd.

Date: Thursday, 10/11/2007 2:54:04 PM
User: Kim Johnston

Process Sheet

(SHORT)

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT
Job Number : 35117
Estimate Number : 10959
P.O. Number : NIA Part Number : D2565207 4
This Issue : 10/11/2007 S.O. No. : NIA Drawing Number : D2565 REV E
Prsht Rev. : NC Project Number : N/A
First Issue : NIA Type : SMALL / MED FAB Drawing Revision : E
Previous Run : 31245 Material : NIA
Written By : Due Date : 10/17/2007 Qty: 10 Um: Each
Checked & Approved By : 07.10.11
Comment : Est: D 01.08.28 Added Powder coat, and added Inspection level 3 and 21. SM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 1.8812 f(s)/Unit Total : 18.8118 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M 105732

SB 07/10/15

(10)

2.0 BRAKE NC NC BRAKE



Comment: BRAKE NC

Punch as per Dwg D2565 using DT 8313

SB 07/10/15

(10)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr and polish

SB 07/10/15

(10)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/16

confer

(410)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

SB 07-10-17

M-L 07-10-18

(P10)

(410)

(4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 07/10/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/18	5.0	4 (Four) Arms have the mat. manufacture burr come through the powder coat. R.C. Parts were not cleaned properly.	<u>Q51012</u>	Scuff entire Arm and grind off to remove the burr. Re Powder coat AS Per Q57005	<u>JS</u> 07-10-18 <u>4</u>	<u>U.</u> 7/10/18	<u>Q51012</u>	<u>JS</u> 07/10/18

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 35117

Part Number: D2565207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/10/18 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *52253*

PC 7/10/18 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/07/10/24 (4)

Job Completion



U 07-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

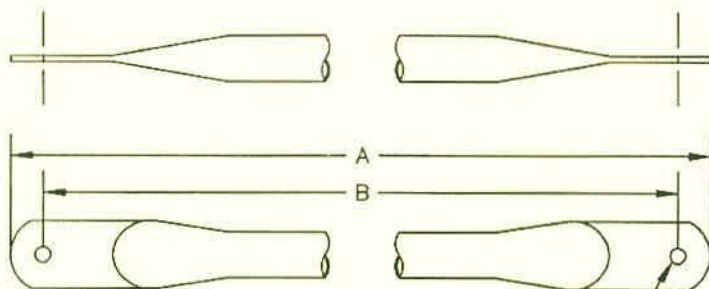
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

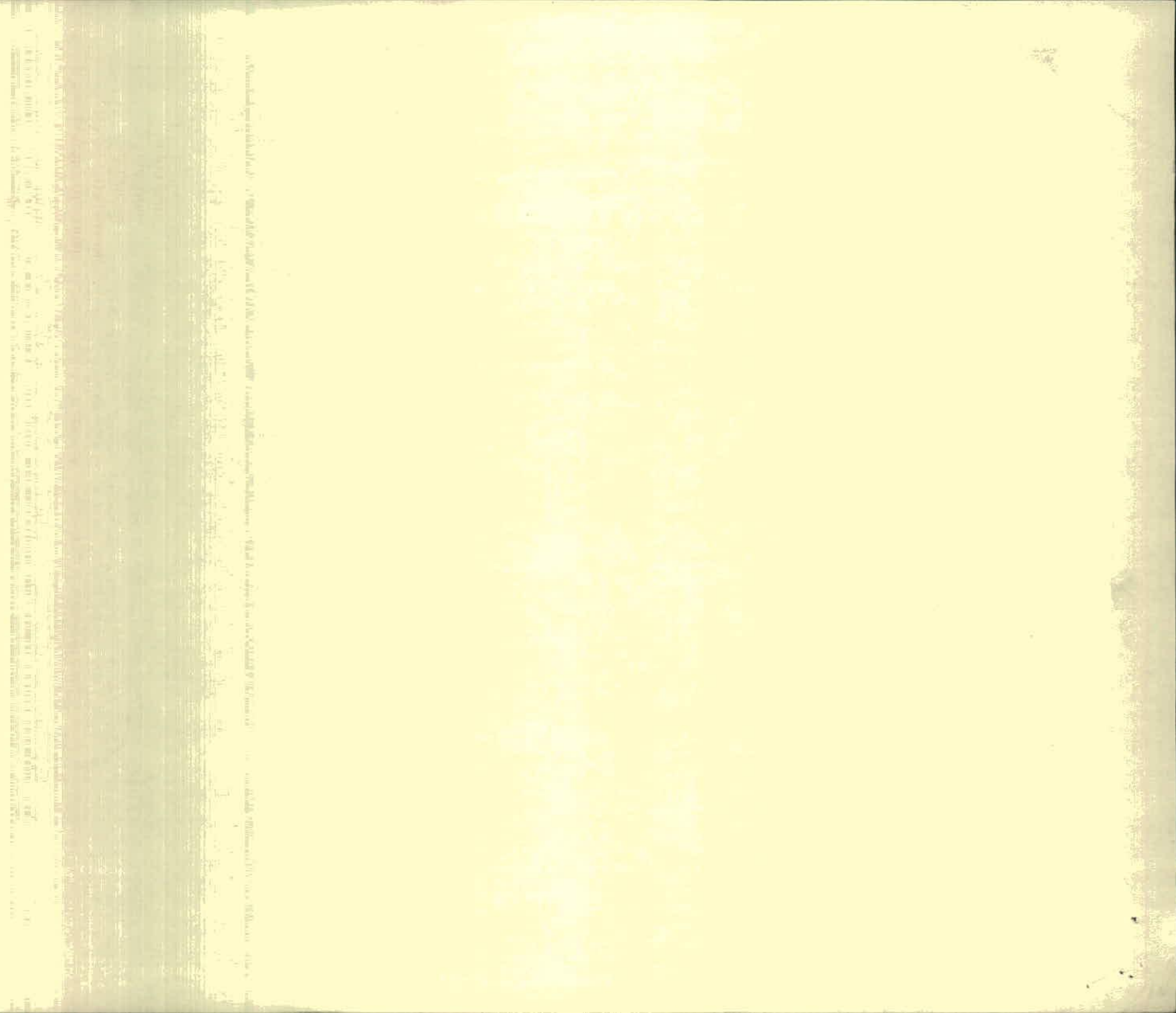
GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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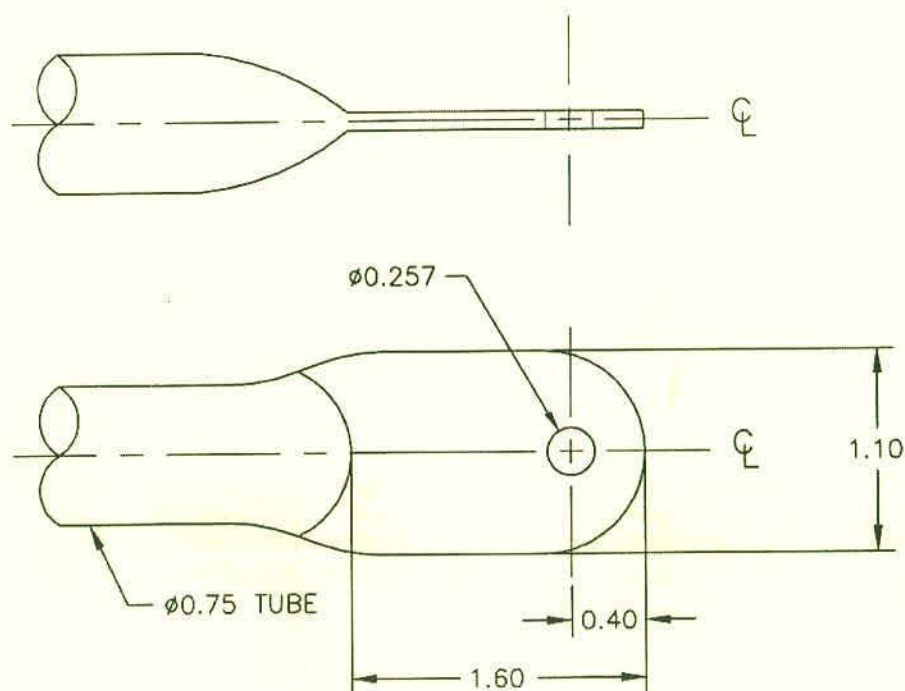




DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MB	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28	TITLE PUNCH DT8117 SPEC CONTROL		SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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